

Work Order ID 77295

December-01-11 3:12:24 PM

Glossy Black ship Dec 9
77295

Page 1

Item ID: D350-591-214GB

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step. Short RH

Start Date: 12/01/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/06/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

5/12/09

HJ for MLJ 11-12-8
①

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

11-12-01

1 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 12/06/11 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

M 11-12-07 12.02 (1)

130

Large Fab

0.00

130

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078
A/RAluminum Rod 114514
3-Grind End Plate flush 118734

11-12-07 1 0

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

140

QC

Memo

0.00

Quality Control

1 0 11-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 12/06/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

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1

Cust Item ID:

Required Date: 12/06/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00

200

Large Fab

Large Fab

Memo

0.00

Large Fab

1- Rivet Leg Assembly as per Dwg D3078.

2-Bevel Aft end for welding

3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod 114514

5-Grind End Plate flush

11.12.07 1 φ

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.00

Quality Control

8.11.12.07

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Item ID: D350-591-214GB

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Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step, Short RH

Start Date: 12/01/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/06/11 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00

220

QC

Memo

0.00

Quality Control

230

Chemical Conversion Coat per QSI005 4.1

0.00

230

HandFinish

Memo

0.00

Hand Finishing

240

White Gloss (Ref: 4.2.3.2) per QSI005 4.3-Steel

0.00

240

Powdercoat

Memo

0.00

Powder Coating

ATTN:

PAINT GLOSSY BLACK

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:10
320°F
11:40

21RH

1X M-L 11/12/08

1X M-L 11/12/08

m 118025

Work Order ID 77295

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Setup Start *NS1*

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Stop *NS2*

Item Name: Heli-Access-Step, Short RH

Start Date: 12/01/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/06/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

250

Wing Walk as per dwg QSi005 4.4 Batch 118988 0.00

250

HandFinish

Memo

0.00

Hand Finishing

260

QC3- Inspect Part Finish

0.00

260

QC

Memo

0.00

Quality Control

1 f all 4/12/08
counted & measured

270

Pick Kit

0.00

270

Packaging

Memo

0.00

Packaging

Puff 2/08 @

Work Order ID 77295

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77295

Page 7

Item ID: D350-591-214GB

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Short RH

Stop ***NS2***

Start Date: 12/01/11 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/06/11 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

280

QC4- 100% Inspect kits for completeness

0.00

280

QC

Memo

0.00

Quality Control

290

Packaging

0.00

290

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-214

Location:

PPP Rev: E

300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

11/12/11
11/12/11
11-12-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-01-11 3:12:23 PM

Page 2

Work Order ID: 77295

Parent Item: D350-591-214GB

Parent Item Name: Heli-Access-Step. Short RH

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W4

Rivets

Purchased

No

200

Each

1.862.0000

16

16

Location

Loc Qty

Loc Code

ST321

116188

1857

59

117364

253

117601

200

117885

195

118840

1150

WA018

5

116712

5

Manufactured

No

200

Each

33.0000

1

1

Location

Loc Qty

Loc Code

WA

33

66149

0

76193

31

76194

2

Manufactured

No

200

Each

125.0000

1

1

Location

Loc Qty

Loc Code

WA016

125

67582

2

68214

1

75468

32

76179

90

Purchased

No

270

Each

82.0000

4

4

Location

Loc Qty

Loc Code

ST358

82

117872

32

118838

50

AN4-16A

Bolt

Purchased

No

270

Each

82.0000

4

4

Location

Loc Qty

Loc Code

ST358

82

117872

32

118838

50

December-01-11 3:12:23 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-01-11 3:12:23 PM

Work Order ID: 77295

Parent Item: D350-591-214GB

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

D2732 Manufactured No

270 f 364.4200 1 1

Rubber Extrusion

Cut 3.00" long, qty 4.

Location

Loc Qty

Loc Code

ST410

364.42

70987

364.42

AN3-35A Purchased No

270 Each 145.0000

Bolt

Location

Loc Qty

Loc Code

ST353

145

117619

3

119449

100

119641

42

AN4-11A Purchased No

270 Each 240.0000

Bolt

Location

Loc Qty

Loc Code

ST356

240

110382

1

115316

39

117872

100

118706

100

AN960JD416 NAS1149D0463J Purchased No

270 Each 0.0000

Washer

D2230-3

Lug

Manufactured No

270 Each 99.0000

Location

Loc Qty

Loc Code

ST480

99

53881

4

70973

1

74440

10

75546

84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-01-11 3:12:23 PM

Work Order ID: 77295

Parent Item: D350-591-214GB

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

* D2856-400 Manufactured No

Abraison Strip

cut 7.20" long, qty 1

02856-400 720

6 7/8 max 12 1/2

Location

Loc Qty

Loc Code

ST409

254.8445

63735

0.6696

68076

0.3149

71164

37.86

73491

216

270

f

254.8445

0.6

0.6

74038

MS21042L3

Purchased

No

Nut

Location

Loc Qty

Loc Code

ST300

108

117441

16

117885

35

118451

5

118927

52

ST516

5994

119017

5994

ST518

1702

119075

1702

270

Each

7,804.0000

12

2

AN4-13A

Bolt

Purchased

No

Location

Loc Qty

Loc Code

ST357

1053

118078

17

118838

436

119449

500

119798

100

270

Each

1,053.0000

4

4

119075

118838

12/12/08 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

December-01-11 3:12:23 PM

Work Order ID: 77295

Parent Item: D350-591-214GB

Parent Item Name: Heli-Access-Step. Short RH

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

D2230-1 Lug *Glossy Black* Manufactured No

270 Each 27.0000

2 76690

Location

Loc Qty

Loc Code

ST480

27

67826

6

70974

3

72811

18

MS21042L4 Nut Purchased No

270 Each 10,452.000

6 6

Location

Loc Qty

Loc Code

ST300

537

117441

51

117601

353

118451

133

ST516

4915

119017

4915

ST518

5000

119075

5000

AN960JD10

NAS1149D0363J

Washer Purchased No

270 Each 0.0000

4 4

119537 Puff/s

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

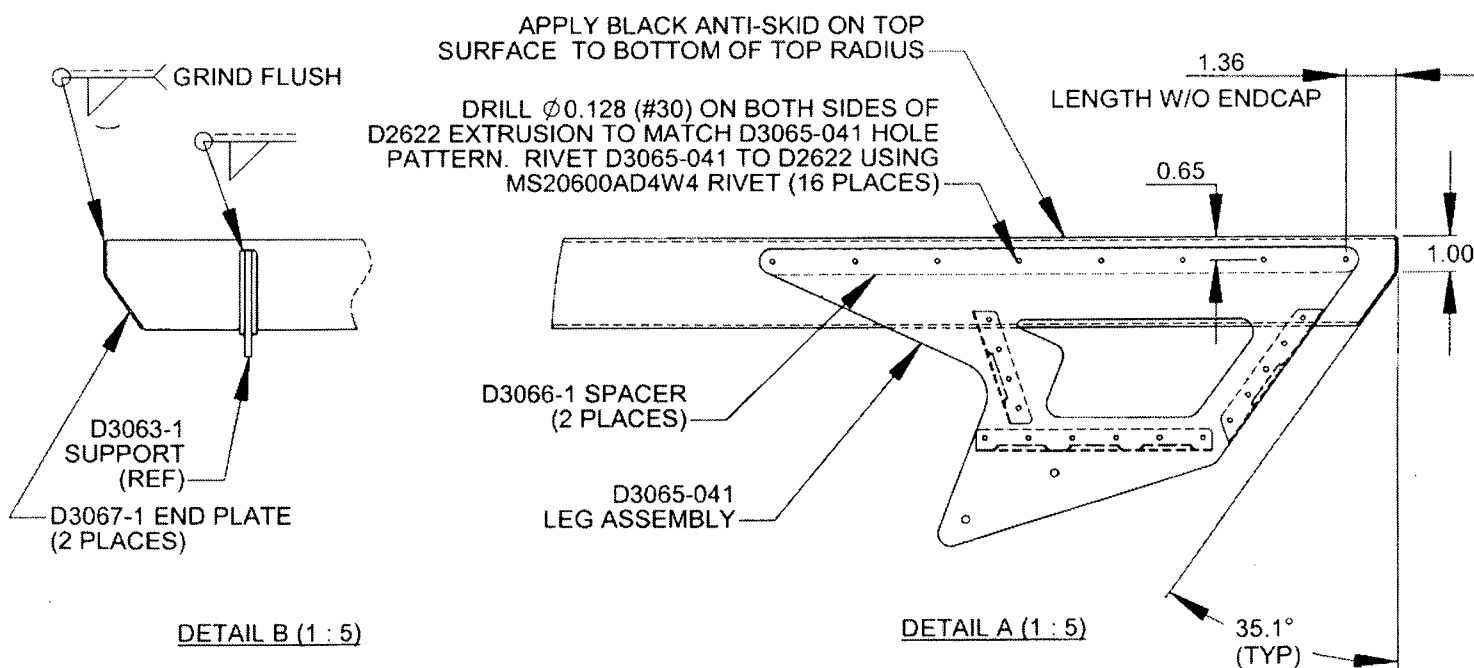
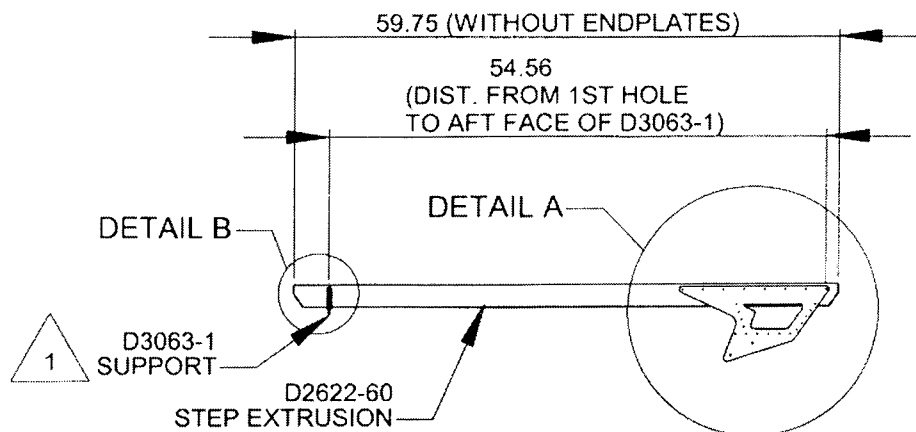
W/O 77295

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. A
DATE	DRAWING NO.	SHEET 2 OF 2
02.09.11	D3078	SCALE 1:20
	TITLE	
	STEP ASSEMBLY, HI SHORT	



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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE


For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X	II			D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
	II	X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
	II		X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	NCA	DSI 9472	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BOLT ADDITION	NTS
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